

Work Order ID 70537

Friday, June 10, 2011 2:55:52 PM



Page 1

Item ID: D206-558-041

Accept

Revision ID:

Item Name: Single Cargo Mirror Assembly

Start Date: 6/10/2011 Start Qty: 1.00

Required Date: 6/15/2011 Req'd Qty: 1.00

Reference:

Approvals:

Process Plan:

Date: 11-06-13

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

IIN D206-558

Rev C

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and type labels as per PPP D206-558-041 DSI 9436
CHG009

S u l o g l i b

11-06-13 BG 11-6-15

110

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

Assemble as per Dwg D206-558
PAGE 10 IN BLUE FILE

11/06/13

120

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

S u l o g l i b

tu

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 70537

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Page 2

Item ID: D206-558-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Single Cargo Mirror Assembly

Start Date: 6/10/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 6/15/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

125

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

11/6/15

130

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

5/16/16



140

Packaging

0.00



Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D206-558-041 DSI 9436

Location: _____

PPP Rev: _____

6/16/16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 70537

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Page 3

Item ID: D206-558-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Single Cargo Mirror Assembly

Start Date: 6/10/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 6/15/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/6/2011

MF

11-06-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries





Friday, June 10, 2011 2:56:03 PM

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Required Qty: 1.00

Comments: IPP F02.09.19 Re-format; Incorporated D2065 KJ
IPP Rev:G 08-05-14 now @ chg006/ add D3778-1 per ECN1171 DD
verified:ec
IPP Rev:H 08-08-19 now @ chg 007 DD verified by:ec IPP Rev:I
10.03.17 add pick kit DD verified by:JLM IPP REV:J 11.01.19 AS
PER CHG009 DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN960JD10 	NAS1149D0363J	Purchased	No			110	Each	0.0000	4	4			
Washer													
D2011-101 		Manufactured	No			110	Each	16.0000	1	1			
6" Mirror													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST221				16					
				65838				16					
D2052 		Manufactured	No			110	Each	20.0000	2	2			
Mounting Bracket													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				GA				20					
				67743				20					
D2053 		Manufactured	No			110	Each	10.0000	1	1			
Mounting Bracket													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST005				10					
				65837				10					

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR: Yes No** **DQA:** _____ **Date:** _____
Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Friday, June 10, 2011 2:56:03 PM

Page 2

Work Order ID: 70537

Parent Item: D206-558-041

Parent Item Name: Single Cargo Mirror Assembly

Start Date: 6/10/2011

Required Date: 6/15/2011

Start Qty: 1.00

Required Qty: 1.00

D2054

Bushing

Manufactured No

110 Each

50.0000

2

2

Location

Loc Qty

Loc Code

GA

50

61834


4

67784

46



EP 11/06/13

D2055

Clamp

Manufactured No

110 Each

10.0000

1

1

Location

Loc Qty

Loc Code

GA


10

66184

10



EP 11/06/13

D2056

Bell Crank

Manufactured No

110 Each

3.0000

1

1

Location

Loc Qty

Loc Code

GA

3

66183

3



EP 11/06/13

D2057

Plug

Manufactured No

110 Each

5.0000

1

1

Location

Loc Qty

Loc Code

ST005

5

60880

5



EP 11/06/13

D2065

Arm

Manufactured No

110 Each

6.0000

1

1

Location

Loc Qty

Loc Code

ST229

6

61381

6



EP 11/06/13

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Page 3

Work Order ID: 70537

Parent Item: D206-558-041

Parent Item Name: Single Cargo Mirror Assembly

Start Date: 6/10/2011

Required Date: 6/15/2011

Start Qty: 1.00

Required Qty: 1.00

MS21042L3

Purchased

No

110

Each

2,307.000

2

Nut

Location

Loc Qty

Loc Code

ST300

2307

108701

12

116391

9

116549

586

117441

800

117601

400

117885

500

MS27039-1-18

Purchased

No

110

Each

96.0000

2

Screw

Location

Loc Qty

Loc Code

ST292

96

115589

96

AN3-4A

Purchased

No

125

Each

672.0000

4

Bolt

Location

Loc Qty

Loc Code

ST350

672

104291

300

104625

300

114374

72

AN526-1032R9

Purchased

No

125

Each

140.0000

4

Screw

Location

Loc Qty

Loc Code

ST328

140

116900

40

117395

100

Friday, June 10, 2011 2:56:04 PM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Friday, June 10, 2011 2:56:04 PM

Work Order ID: 70537

Parent Item: D206-558-041

Parent Item Name: Single Cargo Mirror Assembly

Start Date: 6/10/2011

Required Date: 6/15/2011

Start Qty: 1.00

Required Qty: 1.00

AN960JD10L NAS1149D0332J Purchased No

125

Each

0.0000



Washer

D2067

Manufactured No

125

Each

32.0000



Connector

Location

Loc Qty

Loc Code

ST005

32

67403

32

D2071

Manufactured No

125

Each

18.0000



Cable Assembly

Location

Loc Qty

Loc Code

ST222

18

66317

3

69196

15

D3778-1

Manufactured No

125

Each

10.0000



Bracket

Location

Loc Qty

Loc Code

ST228

8

68695

8

ST277

2

65835

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

Friday, June 10, 2011 2:56:04 PM

Work Order ID: 70537

Parent Item: D206-558-041

Parent Item Name: Single Cargo Mirror Assembly

Start Date: 6/10/2011

Required Date: 6/15/2011

Start Qty: 1.00

Required Qty: 1.00

MS21042L3

Purchased

No

125

Each

2,307.000



Nut



1
sp

Location

Loc Qty

Loc Code

ST300

2307

108701

12

116391

9

116549

586

117441

800

117601

400

117885

500

1

MS21919-DG5

Purchased

No

125

Each

32.0000



Clamp



2
sp

Location

Loc Qty

Loc Code

ST306

32

117395

32

2

MS35489-9

Purchased

No

125

Each

52.0000



Grommet



1
11/6/11 sp

Location

Loc Qty

Loc Code

ST296

52

107376

52

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

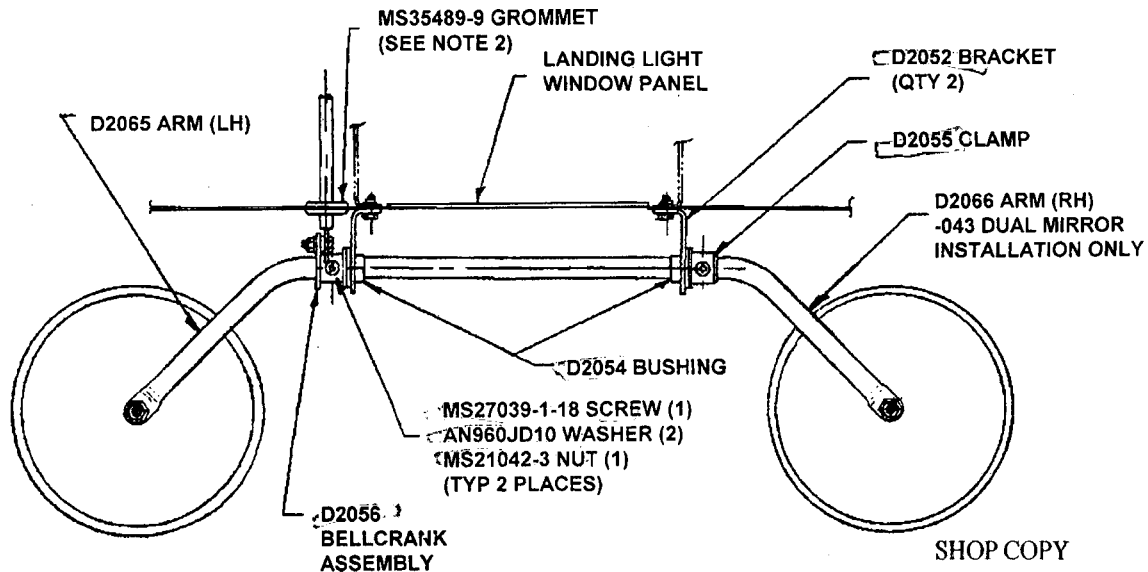


Figure 25.2 - View A: Looking Aft.
(D206-558-043 Mirror Shown)

SHOP COPY
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 70537

11-06-23

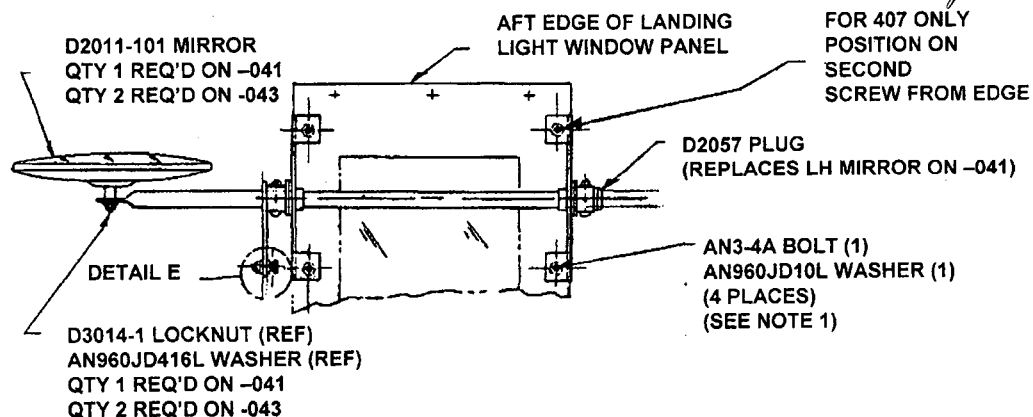


Figure 25.3 - View C: Looking Down on Mirror Installation
(D206-558-041 Mirror Shown)

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

25.2 CARGO MIRROR REMOVAL

1. Loosen MS21042-3 nut and remove D2071 control cable from D2067 connector.
2. Remove (4) AN3-4A bolts and remove D2052 bracket.
3. Remove (2) AN526-1032R9 screws and (2) MS21919DG5 clamps.
4. Remove (2) AN526-1032R9 screws, the D2053 bracket and the D2071 cable assembly.

25.3 WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D206-558-041	2.4 lb	+5.0 in	+12.0 in-lb	+14.8 in	+35.5 in-lb
Bell 206A/B/L/L1/L3/L4	1.09 Kg	+0.13 m	+0.14 m-Kg	+0.38 m	+0.41 m-Kg
Bell 407					
D206-558-043	3.0 lb	0.0 in	0.0 in-lb	+14.8 in	+44.4 in-lb
Bell 206A/B/L/L1/L3/L4	1.36 Kg	0.0 m	0.0 m-Kg	+0.38 m	+0.52 m-Kg
Bell 407					

25.4 PARTS LIST

Qty -041	Qty -043	Part Number	Description
X		D206-558-041	SINGLE CARGO MIRROR ASSEMBLY
	X	D206-558-043	DUAL CARGO MIRROR ASSEMBLY
1	2	D3014-1	* LOCKNUT
1	1	D2071	CABLE ASSEMBLY
2	2	D2054	BUSHING
1	1	D2067	CONNECTOR
	1	D2066	ARM
		D2065	ARM
		D2057	PLUG
	1	D2056	BELLCRANK ASSEMBLY
	1	D2065	CLAMP
1	1	D2053	BRACKET
2	2	D2052	BRACKET
1	2	D2011-101	MIRROR ASSEMBLY
4	4	AN3-4A	BOLT
4	4	AN526-1032R9	SCREW
1	2	AN960JD416L	* WASHER
4	4	AN960JD10L	WASHER
6	6	AN960JD10L	WASHER
3	3	MS21042-3	NUT (or MS21042L3)
2	2	MS21919DG5	CLAMP
2	2	MS27039-1-18	SCREW
1	1	MS35489-9	GROMMET

* INCLUDED AS PART OF D2011-101 MIRROR ASSEMBLY

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